KH-323 SERIES OPERATION MANUAL

COMPUTERIZED FLAT KNITTING MACHINE
DEAR CUSTOMER:

Welcome to be an owner of KH-323 series computerized flat knitting machine as Kauo Heng endeavors to maintain a high standard of this machine, we also pleased for your cooperation to make the machine serve longer by reading this operator manual carefully before commencing your production.

Yours sincerely,
Kauo Heng Precision Machinery Industrial Co., LTD.

Address: No. 20, Lane 14, Ho Ping Rd., Panchiao, Taipei, Taiwan
Tel: 886-2-29559258
Fax: 886-2-29629153
E-mail: kauoheng@ms58.hinet.net
Website: www.kauoheng.com.tw
OVERVIEW OF KH-323 SERIES

1. Yarn carrier selection
2. Carriage
3. Operation bar
4. Main cover
5. Fabric take-down roller
6. Controller
7. Main motor
8. Side tension
9. Top tension
10. Side cover
1. Points to observe

① Installation Environmental Conditions

Please install the machine as below instructions in order to use this machine in the best condition for a long period of time.

Do not install the machine at a place subject to direct sunshine and/or adjacent to a heat generation source such as a furnace/oven.

Do not install the machine at a place subject to rapid temperature changes.
The temperature should be 0℃~35℃ inside the controller.

Do not install the machine at a place where there is a lot of dust and dirt, or a location affected by chemical gases, sea breeze etc.

Do not install the machine at a place subject to excessive moisture.
The humidity should be 30 % ~ 80 %

Do not install the machine on a slope or unstable place.

Please connect the electric power and make sure the ground wire is connected correctly.
② Fig. 1.1 illustrates the correct position of jacking while moving the machine. It is very important when moving the machine. The yarn carrier rail shall never be used to push the machine since it will distort the rail.

![Correct position of jacking the machine](image)

③ When connecting the electric power, attention must be paid to the correct voltage. And make sure the ground-wire connected.

2. Installation

① After unpacking and locating the machine in the factory, it must be leveled carefully with a spirit-level to avoid machine distortion in running. We recommend the machine to be leveled with rubber peddings for best result. Remove grease from the polished parts before starting to operate the machine. About the moving parts must be lubricated according to the following instruction.

<table>
<thead>
<tr>
<th>Lubrication points</th>
<th>Lubricant</th>
<th>Frequency</th>
</tr>
</thead>
<tbody>
<tr>
<td>Carriage</td>
<td># 10 oil</td>
<td>Daily</td>
</tr>
<tr>
<td>Carrier rail</td>
<td># 10 oil</td>
<td>Daily</td>
</tr>
<tr>
<td>Needle bed</td>
<td># 10 oil</td>
<td>Daily</td>
</tr>
<tr>
<td>Driving parts</td>
<td>Hi-temp grease</td>
<td>Weekly</td>
</tr>
</tbody>
</table>

Table 2.1 Lubrication

② Raise the yarn stand till the end of the tubes is leveled with the base plate, tighten the screws and connect the plug of stop motion situated at the left rear end.
3. Operation

3.1 Power switch

As Fig. 3.1 front side of controller, easily find two switches. Flip upward is “ON” and downward is “OFF”.

![Fluorescent lamp switch](image)

![Breaker/power switch](image)

Fig. 3.1 Front side of controller

3.2 Operation bar

① Inching: When turning forward of the operation bar, machine operates slowly and stops when you loosen.

② Starting: When turning backward of the operation bar, machine starts. Machine starts from slow speed and runs in preset speed when reaching the first terminal sign.

③ Stop: When the machine is running, you can turn operation bar in any direction to stop machine.

④ Machine executes protection mode automatically when machine stops over 3 seconds. You must turn twice backward of the operation bar to start.

![Inching](image)

![Starting](image)

Fig. 3.2 Starting operation bar
3.3 Yarn feeder

The position of carrier is adjusted according to the desired knitting width, correctly make yarn feeder beside the end working needle by 10 ㎜. The yarn feeder must be in the central position between front and rear needles, also check its height refer to Fig.3.3. When work several yarn feeder in knitting, the position of carrier should be adjusted to make each yarn feeder not be overlapped, it avoids damage of the parts. The yarn carrier on rail must be adjusted in easy moving, adjustment refers to Fig.3.4.

![Fig.3.3 Position of yarn carrier](image1.png)

Loosen two screws to adjust up & down

![Fig.3.4 Adjustment of carrier](image2.png)
3.4 Top tension

Top tension springs should have the correct tension, the opening of the knot-catcher must be set according to the yarn count that is being knit-ted.

![Top tension diagram](image)

3.5 The latch brush

Latch brush is important to prohibit the needle latch to close in knitting, the correct brusk setting is illustrated in Fig.3.6.

![Latch brush diagram](image)
4. Clear filter

Filters are equipped in the controller and in the parts of main motor, it prohibits dust to come inside. Please take out the filter and dust it often refer to Fig.4.1.

![Filter](image)

Fig.4.1 Cleaning filter

5. Needle bed

5.1 KH-323D needle bed

KH-323D the structure of front and rear needle bed is the same with regular needle high butt and low butt.

![High butt needle](image)

![Low butt needle](image)

![Steel wire, Butt needle, Needle pressing plate](image)

Fig.5.1 The structure of front & rear needle bed
For the knitting needles in unused you don’t need to dismantle them. All you have to do is to push them in the unactive position. In Fig. 5.2 take out the steel wire firstly, and push to the shown area and replace the steel wire.

![Fig. 5.2 Unworked position](image1)

5.2 KH-323DJ&DTJ needle bed

The structure of the front and rear needle bed is the same. KH-323DJ is with regular needles high butt and low butt. KH-323DTJ is with transfer needles high butt and low butt. They both have one kind of jacks on front and rear needle beds.

![Fig. 5.3 The structure of front & rear needle bed](image2)

The unused butt needles and jacks you just push them down to the unworked position. Of course you must pull out and back the steel wire A & B for procedure.

![Fig. 5.4 Unworked position](image3)
6. Cam plate distance

The distance between cam plate and needle bed is maximum 0.15 ㎜, Fig.6.1 shows how to check and adjust. Please check it by every 3 months, loosen the stepped screw and turn the bearing pin to adjust the distance, make sure to tighten the stepped screw after adjustment.

Fig.6.1 Adjust cam plate distance

7. Remove carriage

When it becomes necessary to remove the carriage, it can be remove from the left hand side or the right hand side. The procedures are as following:

1) Turn off the power firstly.
2) Remove the side cover.
3) Disconnect the two plugs on back of carriage.
4) Remove the fitting screw and cap bolt on connecting plates as shown in Fig.7.1. Then pay attention to remove the carriage.
5) After replacing the carriage, it must be confirmed that the plugs, fitting screws and cap bolts are all completely connected, then start machine.

Fig.7.1 Remove the carriage
8. Fabric take-down system

In principle of the take-down tension strength must be small and average. The take-down system is controlled by torque motor. There are two important things to adjust the take-down tension strength. First method is the two speeds No.1 and No.2 as Fig. 8.1 adjust each with turning knob and set the speed, the tension strength is larger and the speed is faster. You input the numeric in program to select the speed you want.

Second method is the roller. Each roller can be adjusted individually. The pressure of roller gets larger and the speed of fabric take-down gets faster.

To detect fabric falling or wraparound, there is equipped with a press-off detector in the front of roller and a fabric roll-up detector in the back of roller. The machine will stop automatically when the fabric happens fall or wraparound.

![Fig. 8.1 Micro adjustment of torque motor](image)

![Fig. 8.2 Fabric take-down system](image)
9. Racking mechanism

① The rear bed can be racked five (5) pitches, the initial position”0”. See the left selvedge of needle bed, the corresponding position that the first needle of rear is on the left hand side of the first needle of front. As shown in Fig.9.1.

② In editing instruction you can choose the left racking or the right racking by one pitch.

③ In each racking position the rear bed and the front bed must be kept in correct corresponding relation. You check it with pushing one front needle to tuck position, the hook of front needle and the knock-bit of rear bed should be at the same position.

④ If there has racking instruction in programming, you must enter the test mode to rack the needle bed in the set position before you execute tun, and make sure the racking mechanism is matched your programming.

⑤ Needle position of transfer must be at the left –2.5 and at the right +3.5 of needle bed.

⑥ If the corresponding position of needle bed is not proper, loosen the stepped screws and adjust the rear bed to correct position, then tighten the stepped screws after adjustment. Refer to Fig.9.2.
10. Carriage combination and separation

KH-323 series is equipped with two carriages, you can choose in use of combination or separation by yourself for different knitting production. Please operate combination or separation as follows:

1. Turn off power.
2. Fig.10.1 is a top overview of carriages.
3. Loosen the four screws unconnected plate of driving belt, push the connecting-block to the direction of carriage to pass, then take off the connecting-block.
4. In separate situation, the interval of two knitting piece must be minimum 180 mm. (Each 90 mm inactive area to left and right from the central needle.)
5. Move carriage to the marked position on belt, and replace the belt fixed connecting-block.
6. Move the left orange relay which is on the back of driving belt as follows.

In separation, the left relay should be on the central position.
In combination, the left relay should be on the side position.

Combination position  Separation position

![Fig.10.1 Combination & separation carriage](image-url)
11. KH-323D Cam system

KH-323D the cam system of front & rear needle bed is the same.
Fig11.1 is overview of front & rear cam system.

Fig.11.1 Front & rear cam system

A  Bridge cam
B  Needle clearing cam
C  Needle raising cam
D  Stitch cam
E  Stitch cam
F  Needle guide cam
G  Needle guide cam
H  Stitch guide cam
I  Stitch guide cam
12. KH-323D Cam action

In graphs show the usual kinds of cam active situation. “ARROW” means the carriage knitting direction. Cam of “slant-line” area is in half raising, and also the position of low butt needle “miss” and high butt needle “knit”. Cam of “cross-line” area is in raising position and all butt needles are without any action. Following figures are with drawing description according to action.

Fig.12.1 Command 0: All butt needle MISS

Fig.12.2 Command 1: All butt needle KNIT
Fig. 12.3 Command 2: All butt needle TUCK

Fig. 12.4 Command 3: High butt needle KNIT
Fig. 12.5 Command 4: High butt needle **KNIT**
Low butt needle **TUCK**

Fig. 12.6 Command 5: High butt needle **TUCK**

- High butt needle
- Low butt needle
13. **KH-323DJ Cam system**

KH-323DJ the cam system of front & rear needle bed is the same.

Fig13.1 is overview of front & rear cam system.

![Front & rear cam system](image)

Fig.13.1 Front & rear cam system

A Bridge cam  
B Needle clearing cam  
C Needle raising cam  
D Stitch cam  
E Stitch cam  
F Needle guide cam  
G Needle guide cam  
H Stitch guide cam  
I Stitch guide cam  
J Jack raising cam  
K Jack guide cam  
L Jack guide cam
14. KH-323DJ Cam action

In graphs show the usual kinds of cam active situation. “ARROW” means the carriage knitting direction. Cam of “slant-line” area is in half raising, and also the position of low butt needle “miss” and high butt needle “knit”. Cam of “cross-line” area is in raising position and all butt needles are without any action. Following figures are with drawing description according to action.

Fig.14.1 Command 0 : All butt needle MISS

Fig.14.2 Command 1 : All butt needle KNIT
Fig. 14.3 Command 2: All butt needle **TUCK**

Fig. 14.4 Command 3: High butt needle **KNIT**
Fig. 14.5 Command 4: High butt needle **KNIT**

Low butt needle **TUCK**

Fig. 14.6 Command 5: High butt needle **TUCK**
Fig. 14.7 Command 6: Jack **KNIT**

Fig. 14.8 Command 7: Jack **TUCK**
15. KH-323DTJ Front cam system

Fig 15.1 is overview of front cam system.

Fig.15.1 Front cam system

A  Bridge cam
B  Needle clearing cam
C  Needle raising cam
D  Stitch cam
E  Stitch cam
F  Needle guide cam
G  Needle guide cam
H  Stitch guide cam
I  Stitch guide cam
J  Jack raising cam
K  Jack guide cam
L  Jack guide cam
M  Transfer cam
N  Receive cam
O  Transfer guide cam
P  Needle guide cam
Q  Jack raising cam
16. KH-323DTJ Rear cam system

Fig 16.1 is overview of rear cam system.

Fig.16.1 Rear cam system

A  Bridge cam  
B  Needle clearing cam  
C  Needle raising cam  
D  Stitch cam  
E  Stitch cam  
F  Needle guide cam  
G  Needle guide cam  
H  Stitch guide cam  
I  Stitch guide cam  
J  Jack raising cam  
K  Jack guide cam  
L  Jack guide cam  
M  Transfer cam  
N  Receive cam  
O  Transfer guide cam  
P  Needle guide cam  
Q  Jack raising cam  
R  Jack guide cam
17. KH-323DTJ Cam action

In graphs show the usual kinds of cam active situation. “ARROW” means the carriage knitting direction. Cam of “slant-line” area is in half raising, and also the position of low butt needle “miss” and high butt needle “knit”. Cam of “cross-line” area is in raising position and all butt needles are without any action. Following figures are with drawing description according to action.

Fig.17.1 Command 0：All butt needle MISS

Fig.17.2 Command 1：All butt needle KNIT
Fig. 17.3 Command 2: All butt needle TUCK

Fig. 17.4 Command 3: High butt needle KNIT
Fig. 17.5 Command 4: High butt needle **KNIT**
Low butt needle **TUCK**

Fig. 17.6 Command 5: High butt needle **TUCK**
Fig. 17.7 Command 6: Jack **KNIT**

Fig. 17.8 Command 7: Jack **TUCK**
Fig. 17.9 Command 8: Transfer of rear bed & receipt of front bed
Fig. 17.10 Command 8: Transfer of front bed & receipt of rear bed
0. START  2-1
1. EDIT   2-1
2. RUN    2-6
3. FILE   2-12
4. FUNCTION  2-15
5. TEST   2-16
## INSTRUCTION EXPLANATION

<table>
<thead>
<tr>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>Knitting speed</td>
<td>0. Same as previous line</td>
<td></td>
<td>1. 1 (Slow) ～ 7 (Fast)</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Take-down speed</td>
<td>0. Same as previous line</td>
<td></td>
<td>1. No.1 speed</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>2. No.2 speed</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Racking</td>
<td>+10 Rack right 1 pitch</td>
<td></td>
<td>Face to the front of machine, you see the direction of movement of the rear bed.</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>−10 Rack left 1 pitch</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Stitch</td>
<td>Setting from 0～99 (14G)</td>
<td></td>
<td>00 is zero (Tightest)</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Larger numeric gets longer loop.</td>
</tr>
</tbody>
</table>
0. START

When turning on the machine, it will appear this screen and display main menu after you press any key.

When you switch on the machine, then it displays 【MEMORY ERROR】 or 【FILE ERROR】, you must switch off the machine and contact our agent or our service department.

There are five selections in main menu as Fig.0-2 illustrates and numeric corresponds to selection. Please directly press numeric key on keyboard then enter it.

1. EDIT
Press in main menu, then display edit menu. There are five selections in edit menu as Fig.1-1 illustrates.

Fig.0-1

1. EDIT

Fig.0-2

1. EDIT

Fig.1-1

1. EDIT
1.1 OPEN：Open file

Press 1 in edit menu, and then the screen displays as Fig.1-2.

![Fig.1-2](image)

**Remark**：In screen there are five small squares, each one corresponds to F1 ~ F5 on keyboard, blank means out of function. For example, in Fig.1-2, F1 is SURE, F2 ~ F4 are blank in no function, F5 is EXIT. In other screen menu the operation will be the same.

In Fig.1-2, input the file name with numeric, and press F1：SURE；then enter program to edit. When opening the file, input file name which is not existent. And the screen will appear Fig.1-3 warning screen, and then press F1 to enter file or press F5 to exit.

![Fig.1-3](image)

**Edit screen** appears two lines of instructions, cursor stops on the racking position, directly use numeric key and left, RIGHT key to edit instruction, or press UP, DOWN key change to other line. +/- key is for change of rack to left or right. Edit instruction, and please refer the instruction explanation.

![Fig.1-4](image)
INSTRUCTION EXPLANATION

FILE：Insert a file.

NAME: ___  (FILE)
NO: ___

SURE | EXIT

Fig.1-5 Insert file

LINE：After current editing line inset a “ blank line ”, and the following lines are backward.

JUMP：This function is allowed jump to any line. If the input line No. is over total line, it will jump to the last line.

TO: ___  (JUMP)

SURE | EXIT

Fig.1-6 Jump
**F4** DEL: Delete indicated lines.

```
FROM:        (DEL)
TO:
SURE        EXIT
```

Fig.1-7

**F5** EXIT: Press EXIT then the system will ask you to save this file, if it is not a new file, directly press **F1** SURE to use the same file name to save. The screen displays as Fig.1-9 then press **F1**.

If you don’t want to save, press **F5** twice to exit.

**Save file**

---

**FILE ALREADY EXIST! RENAME OR SURE TO SAVE!**

SURE          EXIT

Fig.1-9

---

**FILE ISN’T TO SAVE RESAVE THIS FILE?**

SURE          EXIT

Fig.1-10

---

2-4
1.2 NEW: Open file
After you edit the first line, press \[
\text{F2}
\]
 to insert blank line and go on editing.

1.3 SHIFT: This function will copy left system to right system, or right system to left system, its contents of copy including cam, stitch, yarn carrier.

1.4 YARN: Quickly edit the working yarn carriers of any file.

1.5 STITCH: Quickly edit the working stitch value of any file.

If it has conversion error and the screen displays as Fig. 1-15, press \[
\text{F5}
\]
 to exit.
2. RUN

Fig.2-0

Press 2

☉ Enter RUN mode, if the stepping motor is not at home position, it displays warning 【STEP ERROR】. You should go to the TEST mode, in STITCH function, you can test the stepping motor then come back to RUN mode.

☉ Enter Run mode, if the carriage does not stop at the left limit position, it displays warning 【PLS MOVE CAM TO LEFT】. You have to move the carriage to the left limit position and start.

Fig.2-1

NAME:001   SYS:COMB
STA:010     END:0830
T-PC:9999   F-PC:0025
SURE SEPA   COMB EXIT

Enter Fig.2-1, set the knitting file name, and then set system（carriages）is F2 for separation or F4 for combination, STA（start needle）, END（end needle）, T-PC（total pieces）, F-PC（finished pieces）, after setting press F1 to enter Fig.2-2.
When setting start needle and end needle, please correspond the scale on the needle pressing plate.

As Fig.2-2 and Fig.2-3

Set knitting width Ex. 1
Combination
Real knitting width = 820 needles

Set knitting width Ex. 2
Separation: Base on left side
Real knitting width = 290 needles
After you finish inputting the instruction for the program that occurs incorrect action or wrong instruction to the function of machine, it will automatically appear ERROR message on RUN mode.

## Error Message Table

<table>
<thead>
<tr>
<th>Message</th>
<th>Explanation</th>
</tr>
</thead>
<tbody>
<tr>
<td>Line not even</td>
<td>To edit a program, the total lines of program must be an even number. Otherwise the carriage does not return to the left side to proceed the next knitting piece.</td>
</tr>
<tr>
<td>Carrying feeder</td>
<td>It is an error that the carriage carries a yarn feeder when yet set carriage in an empty action without yarn feeder.</td>
</tr>
<tr>
<td>None feeder (L)</td>
<td>When you set the action of knit, the carriage has to carry a yarn feeder.</td>
</tr>
<tr>
<td>None feeder (R)</td>
<td>Before ending the program, the needle bed must be racked back to the home position. In case the program racks one level to the right, it needs rack one level to the left back to the home position before ending.</td>
</tr>
<tr>
<td>Rack error</td>
<td>Before ending the program, the yarn feeder must return to home position. Otherwise it is impossible to proceed the next knitting piece.</td>
</tr>
<tr>
<td>Feeder 1 error</td>
<td>Repeat must be set in even lines of amount, for example the start line is an odd and the end line must be an even, or from an even to an odd. (From odd line to odd line or from even line to even line are unacceptable.)</td>
</tr>
<tr>
<td>Feeder 2 error</td>
<td></td>
</tr>
<tr>
<td>Feeder 3 error</td>
<td></td>
</tr>
<tr>
<td>Feeder 4 error</td>
<td></td>
</tr>
<tr>
<td>Feeder 5 error</td>
<td></td>
</tr>
<tr>
<td>Feeder 6 error</td>
<td></td>
</tr>
<tr>
<td>Repeat error</td>
<td>In racking, the maximum of knitting speed is No.4.</td>
</tr>
<tr>
<td>Start-ndl error</td>
<td>The number of start-needle must be smaller than the number of end-needle.</td>
</tr>
<tr>
<td>End-ndl error</td>
<td>The number of end-needle must be larger than the number of start-needle, or smaller than the number of total-needle.</td>
</tr>
</tbody>
</table>

Tab.2-1 Error message table

Please correct the error of edited program according to the error message of LCD display.
After finishing checking the system and confirming the program executive then the screen displays as Fig.2-4.

![Fig.2-4](image)

In Fig.2-4, column 1 and 2 display T-RW (total executive lines), F-LN (total file lines), YN-L (yarn carrier of left system), YN-R (yarn carrier of right system). Column 3 displays CRG-L (the left carriage), CRG-R (the right carriage), \( \text{F2} \) for open (action), \( \text{F4} \) for close (inaction). Finish setting and press \( \text{F1} \) to enter Fig.2-5.

![Fig.2-5](image)

Right side of screen display

- File name: (004)
- Set pcs: (9999)
- Finished pcs: (0055)

- **RUN**: Turn the operation bar for knitting.
- **EDIT**: Edit stitch value and knitting speed. See Fig.2-6 and Fig.2-7 and Fig.2-8.
- **1 PC**: Knit 1 piece and stop machine.
- **HOME**: Give up the fabric on knitting. The method you turn the operation bar to stop machine, and press \( \text{F4} \) to make cam and stitch to home position, and then start the operation bar to make the carriage return to left beginning position.
Fig. 2-6 Edit stitch value & knitting speed
Press \[ \text{F5 ENTER} \] enter Fig. 2-7
Press \[ \text{F5 ENTER} \] enter Fig. 2-8

Fig. 2-7
Fig. 2-7 displays all the used stitch value of file. Directly move the cursor to the area of being changed, and press the numeric key to correct it. For example, in Fig. 2-7 the 12 is replaced by 15, then all the stitch value 12 is/are changed with 15 in this file.

Fig. 2-8
Fig. 2-8 displays the exchange of knitting speed. Directly press the numeric key to change knitting speed, or press UP/DOWN key to the changed line and correct it.

Fig. 2-9
Machine stop : If the fault signal (auto-stop equipment) is operated, it will display the fault signal as Fig. 2-9, and corrective action refer to Table 2-2.
<table>
<thead>
<tr>
<th>SIGNAL</th>
<th>FAULT</th>
<th>CORRECTIVE ACTION</th>
<th>REMARK</th>
</tr>
</thead>
<tbody>
<tr>
<td>T-TSN</td>
<td>Yarn break</td>
<td>After corrective action, turn the operation bar to clear, and restart the</td>
<td>Pls contact our agent or service dept., if you still can’t correct the</td>
</tr>
<tr>
<td></td>
<td>Tension loose</td>
<td>operation bar and go on knitting.</td>
<td>fault.</td>
</tr>
<tr>
<td></td>
<td>Yarn knot</td>
<td></td>
<td></td>
</tr>
<tr>
<td>S-TSN</td>
<td>Yarn break</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>Tension loose</td>
<td></td>
<td></td>
</tr>
<tr>
<td>DETR</td>
<td>Needle break</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>Fabric rise</td>
<td></td>
<td></td>
</tr>
<tr>
<td>TK-DN</td>
<td>Fabric fall</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>Fabric roll-up</td>
<td></td>
<td></td>
</tr>
<tr>
<td>STOP</td>
<td>Safety cover is not closed.</td>
<td></td>
<td></td>
</tr>
<tr>
<td>OVER</td>
<td>Motor rotates without signal of detector. Overload of inverter.</td>
<td>Switch off power and switch on after 5 sec. Switch off power to check power in correct then switch on.</td>
<td></td>
</tr>
<tr>
<td>LEFT/RIGHT</td>
<td>Carriage is stroke error.</td>
<td>Push the carriage out of limit sensor.</td>
<td></td>
</tr>
<tr>
<td>STEP</td>
<td>Stepping motor error</td>
<td>Press [F4] HOME to return carriage to left limit position. Exit RUN mode and go to TEST mode to test stitch value and go back RUN.</td>
<td></td>
</tr>
<tr>
<td>RACK</td>
<td>Racking error</td>
<td>Press [F4] HOME to return carriage to left limit position. Exit RUN mode and go to TEST mode to test racking and go back RUN.</td>
<td></td>
</tr>
</tbody>
</table>

Table 2-2 Machine stop
3. FILE

Fig.3-1

3.1 DISP: Display
Move cursor to select the displayed file name, and press **F1** SURE the system will execute program once simultaneously, and display screen Fig.3-4. In Fig.3-4, column 1 displays file name and it’s size of used memory. Column 2 displays the beginning position of yarn carrier on the left and the right. Column 3 displays T-RW (total executive line) and F-LN (total file line). Please press **F5** or **F1** to come back to Fig.3-2 after confirmation.

Fig.3-2

Fig.3-3

Fig.3-4

2-12
3.2 DEL: Delete the input file name, and press F1 for sure.

Fig. 3-5

3.3 COPY: Input source file name and target file name, and press F1 for sure.

Fig. 3-6

3.4 TRANS: Transmits file to another machine, firstly confirm if the plug has been connected with connection cable on the back of controller.

Fig. 3-7

Fig. 3-8
Plug for transmitted file on the back of controller.

3.5 REVD: Receive the transmitting file from another machine, firstly confirm if the plug has been connected with connection cable on the back of controller, and press F1 for sure then start to receive.

Fig. 3-9
3.6 CLEAR: Clear all files.

Fig. 3-10

Enter code No: 555
4. FUNCTION

![Fig.4-1](image1)

4.1 STITC: Stitch parameters, directly adjust with numeric. (Machine has two sets of stitch parameters; one is for separation system and the other is for combination system.)

![Fig.4-2](image2)

4.2 TYPE: Setting gauge and total needles, initial setting by manufacturer.

![Fig.4-3](image3)

4.3 BUZZ: Setting buzzer function in action or not.

![Fig.4-4](image4)


![Fig.4-5](image5)
5. TEST

5.1 RACK:

Fig. 5-1

5.2 MOTOR:

Fig. 5-2

5.3 SENSO: Sensor. Test when they are switched on. Sensor with a small square appears in the front.

Fig. 5-4

T-TSN Top tension RACK Racking
S-TSN Side tension DETR Detector
RIGHT Right limit sensor START Operation bar starting
LEFT Left limit sensor INCH Operation bar inching
TK-DN Fabric take-down MEM Memory error
OVER Main motor overload COVER Safety cover
5.4 CAM: Move cursor to make the cam or the yarn feeder solenoid in action.

!(LEFT SYSTEM)
<table>
<thead>
<tr>
<th>YARN</th>
<th>YARN</th>
<th>RIGHT SYSTEM</th>
</tr>
</thead>
<tbody>
<tr>
<td>B</td>
<td>F</td>
<td>B</td>
</tr>
<tr>
<td>SURE</td>
<td>S-L</td>
<td>S-R U-D EXIT</td>
</tr>
</tbody>
</table>

Fig. 5-5

5.5 TK-DN: Setting the speed of fabric take-down, press ►◄ key then turn the operation bar.

!(FOR NO.1 SPEED)
!(FOR NO.2 SPEED)
!(TK-DN MOTOR TEST)
| SURE | | EXIT |

Fig. 5-6

5.6 STITC: Stitch. Press F1 ~ F4 to test.

!(STEP-MOTOR TEST)
| L-BS | L-FS | R-BS | R-FS | EXIT |

Fig. 5-7

5.7 KEYBOARD: Test if it works or not then press F5 to exit.

!(KEYBOARD TEST)
| SURE | | EXIT |

Fig. 5-8
<table>
<thead>
<tr>
<th>Line No.</th>
<th>Knitting Speed</th>
<th>Left Rear Stitch</th>
<th>Left Front Stitch</th>
<th>Rear Left</th>
<th>Rear Right</th>
<th>Cam Left</th>
<th>Cam Right</th>
<th>Right Rear Stitch</th>
<th>Right Front Stitch</th>
<th>Repeat Start-Line</th>
<th>Repeat End-Line</th>
<th>Repeat Count</th>
<th>Description</th>
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</thead>
<tbody>
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</tbody>
</table>

Line No. 001 is not allowed "0" for knitting speed and take-down speed.

Rack:
- 10 Right 1 pitch
- 10 Left 1 pitch

Knitting Speed:
0. Same as previous line
1(Slow) ~ 7(Fast)

Take-down Speed:
0. Same as previous line
1. No. 1 speed
2. No. 2 speed

Yarn carrier:
0. None yarn carrier
1. No. 1 yarn carrier
2. No. 2 yarn carrier
3. No. 3 yarn carrier
4. No. 4 yarn carrier
5. No. 5 yarn carrier
6. No. 6 yarn carrier

Cam:
0. Miss
1. Knit
2. Tuck
3. High butt knit
4. High butt knit, low butt tuck
5. High butt tuck

Stitch: 00–99

Carriage must be on left side for starting.
<table>
<thead>
<tr>
<th>Line No.</th>
<th>Knitting Speed</th>
<th>Left Rear Stitch</th>
<th>Left/Yarn Carrier</th>
<th>Rear Left</th>
<th>Cam Left</th>
<th>Rear Right</th>
<th>Cam Right</th>
<th>Yarn Carrier</th>
<th>Right Rear Stitch</th>
<th>Right Front Stitch</th>
<th>Repeat Start-Line</th>
<th>Repeat End-Line</th>
<th>Repeat Count</th>
<th>Description</th>
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</tbody>
</table>

Line No. 001 is not allowed "0" for knitting speed and take-down speed.

Rack:
- +10 Right 1 pitch
- -10 Left 1 pitch

Knitting Speed:
0. Same as previous line
1 (Slow) - 7 (Fast)

Take-down Speed:
0. Same as previous line
1. No.1 speed
2. No.2 speed

Yarn carrier:
0. None yarn carrier
1. No.1 yarn carrier
2. No.2 yarn carrier
3. No.3 yarn carrier
4. No.4 yarn carrier
5. No.5 yarn carrier
6. No.6 yarn carrier

Cam:
0. Miss
1. Knit
2. Tuck
3. High butt knit
4. High butt knit, low butt tuck
5. High butt tuck
6. Jack knit
7. Jack tuck

Stitch: 00-99

Carriage must be on left side for starting.
<table>
<thead>
<tr>
<th>Line No.</th>
<th>Knitting Speed</th>
<th>Left Rear Stitch</th>
<th>Left Front Stitch</th>
<th>Rear Left</th>
<th>Cam Left</th>
<th>Rear Right</th>
<th>Cam Right</th>
<th>Right Rear Stitch</th>
<th>Right Front Stitch</th>
<th>Repeat Start-Line</th>
<th>Repeat End-Line</th>
<th>Repeat Count</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Rack Take down Speed</td>
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<td>Line No.001 is not allowed &quot;0&quot; for knitting speed and take-down speed</td>
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<td>Rack: +10 Right 1 pitch -10 Left 1 pitch</td>
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<td>Knitting Speed: 0. Same as previous line 1(Slow) ~ 7(Fast)</td>
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<td>Take-down Speed: 0. Same as previous line 1. No.1 speed 2. No.2 speed</td>
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<td>Stitch: 00–99</td>
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</table>

Carriage must be on left side for starting.